Work Orde January-31-13				*965							
Item ID: Revision ID:	D2324		A	Accept	*N900	040	100)* s	Setup Star	1.71	S1*
Item Name: Start Date: Required Date: Reference:	Strut 1/31/13 2/20/13	Start Qty: 6.00 Req'd Qty: 6.00	*6* *6*		Cust Item I Customer:	D:			Stop	*N	S2*
Approvals:	Process Pl	an: MLJ	Date: \3-01-3	Tooling:	Da	ate:	•	I	Run Star	1/1	R1*
••			Date:	SPC (Y/N):		ate:	T AMERICA (MICH.)		Stop	*N	R2*
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Re	vision Nbr									
D2324	Re	v C									_
*100 *100* Small Fab		Small Fab Memo Assemble as	s per Dwg D2324.	0.00				Cax			
110 *110* QC Quality Control	ξ	QC5- Inspect part comp Memo		0.00 Sin)			6			

120

120 Powdercoat

Powder Coating

0.00

Memo

OVEN TEMPERATURE:

6 & BL B-0-07.

NCR: Y	es / No				WORK ORDER NON-	CONFOR	MANCE / UP	DATE			
									QA Closed:	Date	
Work Orde	r:		_		DISPOSITION	_		AGAINST DE	PARTMENT,		
					Rework]	Skic-tube	Crosstube		Water Jet	Engineering
Part N	o				Scrap	↓	Machining	Small Fab		d. Eng. Coor.	Quality
					Use-as-is	Ther	moforming	Finishing	Rec/Stor	re/Packaging	Other
NCR N	o		· · · · · · · · · · · · · · · · · · ·		Work Order Update	J	Large Fab	Composite	j	Supplier	
Root				Descri	ption of work order update	Initial	Act	tion	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chief En	g Desc	ription	Date	Verification	QC Inspector
oc/Data											
quip/Tooling	_								<u>'</u>		
perator	_										
/laterial	_										
etup	_										
Other	-										
rocess											
raining											
Jnapproved	-										
J. Cappioved	i	1	J	l	F	AULT CAT	EGORY		L	1	
Landin	g Gear			· · · · · · · · · · · · · · · · · · ·	General						
ſ	Bending				Bend	Grain			Ovalized		Pressure/Forced
Ī	Centre No	ot Concei	ntric to	o/s	BOM/Route	Hardw	/are		Over/Under	tolerance	Temperature/Cure
	Cracks				Broken/Damaged	Inspec	tion Incomplete		Part Incorre	ct [Weld
	Crushed/	Crimped.			Burrs	Instru	ctioris Incomplete/	Unclear	Part Lost/M	issing	Wrong Stock Pulled
	Cuffs				Contamination	Main	tenance		Part Moved		
	Heat Trea	at			Countersink	Mislab	peled		Positioned V	_	
	Inspectio	n Strip in	Tube		Cut Too Short	Misre			Power Loss/	/Surge	Other
	Ripples in				Drill Holes	Offset					
	Torque W	Vaves in E	xtrusio	n	Drawing	 	Calibration				
	Turning Sequence			Finish	Out of	Sequence					

Outside Dimensions

DQA: Date:

Wave/Twist in Tube

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Orde January-31-13				*96!	572*							Page 2	
Item ID: Revision ID: Item Name:	D2324 Strut			Accept	*N900	040	100)*	Setup	Start Stop	*N:	S1* S2*	- Andrews
Start Date: Required Date: Reference:	1/31/13 : 2/20/13	Start Qty: 6.00 Req'd Qty: 6.00	*6* *6*		Cust Item I Customer:	D:					1 4		
Approvals:		an:	Date:			ate:			Run	Start Stop	1/1	R1* R2*	
Sequence ID/ Work Center II 130 *130* QC Quality Control 140 *140* Packaging Packaging	D	Operation Description QC3- Inspect Part Finish Memo Identify as per dwg & Stoo	ck Location ST 2	-	Tool ID	Tool#	Plan Code	Accept Qty	Qt		Reject Number	Insp. Stamp	
150 *150* QC Quality Control		QC21- Final Inspection - Memo	Work Order Release	0.00				M	בַֿ	13	-02-	78 W 3-2	28

								DQA:	Date:	
NCR: Y	es / No			WORK ORDER NON-O	CONFO	RMANCE / UP	PDATE	QA Closed:	Date:	
Work Orde	r:			DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
Part No				 Rework Scrap Use-as-is Work Order Update	The	Skid-tube Machining rmoforming Large Fab	Crosstube Small Fab Finishing Composite	4	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root Cause	Date	Step	Qty	ption of work order update	Initial Chief Er	l	ction cription	Sign & Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved										
					AULT CA	regory				
Landin	Landing Gear Bending Centre Not Concentric to O/S Cracks Crushed/Crimped Cuffs Heat Treat Inspection Strip in Tube Ripples in Bend Torque Waves in Extrusion Turning Sequence			General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing Finish	Instru Mair Misla Misra Offse	ware ction incomplete uctions incomplete atenance beled ead	/Unclear	Ovalized Over/Under Part Incorre Part Lost/M Part Moved Positioned V	ct sissing	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
Wave/Twist in Tube				Folio	Outside Dimensions					

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

January-31-13 10:36:36 AM

Work Order ID:

96572

Parent Item:

D2324

Parent Item Name:

Strut

Start Date: 1/31/13

Required Date: 2/20/13

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primar Locatio	•	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN3-12A Bolt		Purchased	No				100	Each	169.0000	2	12	4	3/00	/26
				Location	1		Loc Qty	Lo	c Code				/ ,	
				GA			18				/			
					12240)7	18			_lo				
				ST351			51							
					11453	36	1							
					12335	52	50							
				ST512			100							,
					12375	59	100							
AN960JD10 Washer	NAS1149D0363J	Purchased M122378	No. 40	C			100	Each	0.0000	4	24		13/0	2/2
D2324-3	12	Manufactured	No				100	Each	10.0000	1	6 /			1

Bar				
		Location	Loc Qty	Loc Code
		GA	10	
		90731	10	
D2324-5 Strap	Manufactured	No	100 Each	25.0000
		Location	Loc Otv	Loc Code

GA

90776

Loc Code

25

25

1

12 /3/02/20

12

N/CR+	Voc	/ No
NCR:	Yes /	ON

NCR:	Ves	. / No					WORK ORDER NON-O	:01	NFORI	AANCE / UP	PDATE	DQA:	Date:	
		,										QA Closed:	Date:	
							DISPOSITION				AGAINST DE	PARTMENT/	PROCESS	
Vork Ord	er:	-				l	Rework	,		Skid-tube	Crosstube	1	Water Jet	Engineering
Part	No.						Scrap			Machining	Small Fab	Prod	d. Eng. Coor.	Quality
						١	Use-as-is			noforming	Finishing		e/Packaging	Other
NCR	No.						Work Order Update			Large Fab	Composite]	Supplier	
Root					Desc	rip	tion of work order update		nitial	Ac	ction	Sign &		
Cause		Date	Step	Qty		0	r Non-conformance	Ch	ief Eng	Desc	cription	Date	Verification	QC Inspector
oc/Data														
uip/Tooling					•									
perator														
laterial	-													
etup ther			ł											
rocess														
upplier											~ .≽			
raining														
napproved									<u> </u>					
							F	AUL	T CATE	GORY	***************************************			
Land	ng (3			-	_	General		1		 -	7	_	,
	<u> </u>	Bending			-		Bend	<u> </u>	Grain		-	Ovalized		Pressure/Forced
	<u> </u>	Centre No	ot Concer	ntric to (o/s	_	BOM/Route	<u> </u>	Hardwa		-	Over/Under		Temperature/Cure
	⊢	Cracks	o :		-	-	Broken/Damaged	<u> </u>	1	on incomplete	// / /	Part Incorred		Weld Wrong Stock Pulled
	<u> </u>	Crushed/(Cuffs	Crimpea.		-	\dashv	Burrs Contamination	-	Mainte	ions Incomplete,	Onciear	Part Lost/Mi Part Moved	2211.B	Twi only stock rulled
	┝	Heat Trea	.+			\dashv	Countersink	-	Mislabe		-	Positioned V	Vrong	
	\vdash			Tube	-	_	Cut Too Short	\vdash	Misread		 	Power Loss/		Other
	Inspection Strip in Tube Cut Too Short Ripples in Bend Drill Holes				Offset		L		· L					
	Torque Waves in Extrusion Drawing			Out of Calibration										
	Г	Turning S			-	_	Finish	Out of Secjuence						
		Wave/Tw	ist in Tub	e			Folio	Outside Dimensions						

January-31-13 10:36:36 AM

Work Order ID:

96572

Parent Item:

Nut

D2324

Parent Item Name:

Strut

MS21042L3

Purchased

No

Start Date: 1/31/13

7,540.0000

Start Qty: 6.00

Required Date: 2/20/13

Required Qty: 6.00

Location		Loc Oty	Loc Code
FP001		3	
	122141	3	
GA		426	
	122452	426	
ST314		268	
	117885	32	
	119017	55	
	119075	138	
	123265	43	
ST506		6843	
	123900	2843	

4000

123900 124291

100

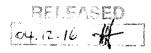
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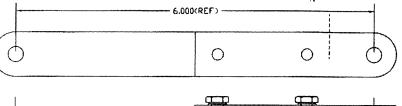
			D	QA:	Date:	
ICR:	Yes / No	WORK ORDER NON-CONFORMANCE / UPDATE	0.4.61			

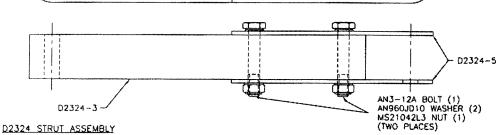
									QA Closed.	Date	· .		
Work Orde	er:				DISPOSITION			AGAINST DE	PARTMENT	PROCESS			
				·····	Rework] [Skid-tube	Crosstube		Water Jet	Engineering		
Part N	lo.				Scrap	1	Machining	Small Fab	Pro	d. Eng. Coor.	Quality		
					Use-as-is	Therr	Thermoforming Finishing			e/Packaging	Other		
NCR N	lo				Work Order Update]	Large Fab Composite			Supplier			
		T	ı		1	1			c: 0				
Root	_	_			ption of work order update	Initial	1	tion 	Sign &	Mar. 251 a. 41 a	061		
Cause	Date	Step	Qty		or Non-conformance	Chief Eng	Descr	ription	Date	Verification	QC Inspector		
Doc/Data	_												
Equip/Tooling													
Operator													
Material													
Setup													
Other													
Process													
Supplier											:		
Training													
Unapproved													
					F	AULT CATE	GORY						
Landir	ng Gear				General				•	<u>.</u>	_		
	Bending				Bend	Grain			Ovalized	L	Pressure/Forced		
	Centre N	ot Concei	ntric to (o/s	BOM/Route	Hardw	are '		Over/Under	tolerance	Temperature/Cure		
	Cracks			[Broken/Damaged	Inspec	tion Incomplete		Part Incorre	ct _	Weld		
	Crushed/	Crimped.			Burrs	Instruc	tions Incomplete/I	Unclear	Part Lost/Mi	issing	Wrong Stock Pulled		
	Cuffs				Contamination	Maint	enance		Part Moved				
ļ	Heat Trea	at			Countersink	Mislab	elecl		Positioned V	Vrong _			
i	Inspection Strip in Tube			Cut Too Short	Misrea	d		Power Loss/	Surge	Other			
İ	Ripples in Bend			Drill Holes	Offset			-					
	Torque V	Vaves in E	xtrusio	n	Drawing	Out of	Calibration						
			Finish	Out of Sec _i uence									
	Wave/Twist in Tube			T _{Folio}	Outside Dimensions								



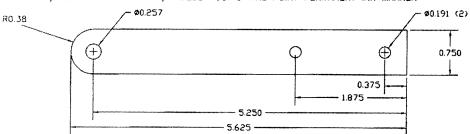
DESIGN B WIL	LIAMS	DRAWN BY PH	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA
CHECKE	2./	APPROVED	DRAWING NO. REV. C
1	11 -	-#-	D2324 SHEET 1 OF 1
DATE	: 2		TITLE SCALE
04.12	2.14		STRUT
Α		94.11.08	NEW ISSUE
В		96.05.07	UPDATE MATERIALS
_		04 12 14	LIPDATE NOTES





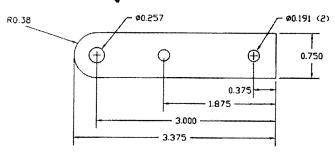


1) IDENTIFY WITH DART P/N D2324 USING FINE POINT PERMANENT INK MARKER



D2324-3

- 1) MATERIAL: 6061-T6/T651 BAR (QQ-A-200/8) 0.75 X 0.75
 - (REF DART SPEC. M6061T680.750X00.750)
- ACID ETCH AND ALODINE PER DART QSI 005 4.1
 POWDERCOAT WHITE (4.3.5.1) PER DART QSI 005 4.3 2) FINISH:
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 4) ALL DIMENSIONS ARE IN INCHES 5) ALL TOLERANCES ARE PER DART OSI 018 UNLESS OTHERWISE NOTED



02324 - 5

- AISI 304/316 STAINLESS STEEL SHEET 16 GAUGE (0.063 THICK) (REF DART SPEC. M304S16GA) 1) MATERIAL:
- POWDERCOAT WHITE (4.3.5.1) PER DART QSI 005 4.3 2) FINISH:
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED